



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D3168-042
Job Sheet 208440



Part No: D3168-042

Job Qty: 1 pcs

Part Name: Step Assembly, Low Short RH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 3/19/20

Job Tracking No:

Due Date: 4/8/20

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV B IPP REV:A 16.03.15 NEW ISSUE DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Lead Time	Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier			
110	Large Fab - Steps - 1	1 pcs			0.00	0.10 0.62	Large Fab - 1			
							Large Fab - 10			
							Large Fab - 2			
							Large Fab - 3			
							Large Fab - 4			
							Large Fab - 5			
							Large Fab - 6			
							Large Fab - 7			
							Large Fab - 8			
							Large Fab - 9			
							Large Fab - 11 (Various)			
							Large Fab - 12			
120	QC 6 QC-5	1 pcs			0.00	0.00	QC 6 - 9			cf
							QC 6 - 68			
							QC 6 - 61			
							QC 6 - 40			
							QC 6 - 81			
							QC 6 - 82			
130	Large Fab - Steps - 2 - B4B	1 pcs			0.00	1.33	Large Fab - 1 - B4B			
							Large Fab - 10 - B4B			
							Large Fab - 2 - B4B			
							Large Fab - 3 - B4B			
							Large Fab - 4 - B4B			
							Large Fab - 5 - B4B			
							Large Fab - 6 - B4B			
							Large Fab - 7 - B4B			
							Large Fab - 8 - B4B			
							Large Fab - 9 - B4B			
							Large Fab - 11 - B4B (Various)			
							Large Fab - 12 - B4B			

ART

EROSPACE

Order No: S265889



3168-042

208440

No/Batch: S265889

ons: Various STC's

Dart Aerospace Ltd.

1270 Aberdeen Street

Hawkesbury, ON K6A 1K7

CANADA

TEL.: 1 613 632-5200

Email: sales@dartaero.com

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Dats: 03/23/20

DAS

24

9-89

DAS

24

9-89

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24
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Container No: S265889



Part: D3168 - 042

Job No: 208440

Serial No/Batch: S265889

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

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Date: 03/23/20

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140 QC 9	1 pcs	0.00 0.00	QC 9 - 10	
			QC 9 - 18	
			QC 9 - 24	
			QC 9 - 43	DAS
			QC 9 - 50	43
			QC 9 - 9	9-89
150 QC 5	1 pcs	0.00 0.00	QC 5 - 10	
			QC 5 - 12	
			QC 5 - 17	
			QC 5 - 18	
			QC 5 - 19	
			QC 5 - 22	
			QC 5 - 24	
			QC 5 - 3	
			QC 5 - 43	DAS
			QC 5 - 49	43
			QC 5 - 51	9-89
			QC 5 - 58	
			QC 5 - 68	
			QC 5 - 9	
			QC 5 - 50	
			QC 5 - 30	
			QC 5 - 40	
			QC 5 - 61	
			QC 5 - 81	
160 Handfinish - 1-1 Chemical-B4B	1 pcs	0.00 0.17	Handfinish - 1 - 1 - B4B	BEB 20-03-26
			Handfinish - 1 - 2 - B4B	
			Handfinish - 1 - 3 - B4B	
			Handfinish - 1 - 4 - B4B	
			Handfinish - 1 - 5 - B4B	
			Handfinish - 1 - 6 - B4B	
			Handfinish - 1 - 7 - B4B	
			Handfinish - 1 - 8 - B4B	
			Handfinish - 1 - 9 - B4B	
			Handfinish - 1 - 10 - B4B	
			Handfinish - 1 - 11 - B4B	
			Handfinish - 1 - 12 - B4B	
			Handfinish - 1 - 13 - B4B	
			Handfinish - 1 - 14 - B4B	
			Handfinish - 1 - 15 - B4B	
			Handfinish - 1 - 16 - B4B	
			Handfinish - 1 - 17 - B4B	
			Handfinish - 1 - 18 - B4B	
			Handfinish - 1 - 19 - B4B	
			Handfinish - 1 - 20 - B4B	
			Handfinish - 1 - 21 - B4B	
			Handfinish - 1 - 22 - B4B	
170 QC 7	1 pcs	0.00 0.00	QC 7 - 10	
			QC 7 - 13	
			QC 7 - 14	
			QC 7 - 15	
			QC 7 - 17	
			QC 7 - 18	
			QC 7 - 19	
			QC 7 - 2	
			QC 7 - 28	
			QC 7 - 3	
			QC 7 - 30	
			QC 7 - 34	

			QC 7 - 36	
			QC 7 - 37	
			QC 7 - 41	
			QC 7 - 47	
			QC 7 - 48	
			QC 7 - 51	
			QC 7 - 58	
			QC 7 - 59	
			QC 7 - 60	
			QC 7 - 9	
			QC 7 - 68	
			QC 7 - 50	
			QC 7 - 67	
			QC 7 - 40	
			QC 7 - 24	DAS
			QC 7 - 43	43
			QC 7 - 61	9-89
			QC 7 - 81	
			QC 7 - 76	
			QC 7 - 79	
			QC 7 - 83	
			QC 7 - 82	
180 Large Fab - Steps - 3 - B4B	1 pcs	0.00 1.33	Large Fab - 1 - B4B	
			Large Fab - 10 - B4B	
			Large Fab - 2 - B4B	
			Large Fab - 3 - B4B	DAS
			Large Fab - 4 - B4B	24
			Large Fab - 5 - B4B	9-89
			Large Fab - 6 - B4B	
			Large Fab - 7 - B4B	
			Large Fab - 8 - B4B	
			Large Fab - 9 - B4B	
			Large Fab - 11 - B4B (Various)	
			Large Fab - 12 - B4B	
190 QC 5	1 pcs	0.00 0.00	QC 5 - 10	
			QC 5 - 12	
			QC 5 - 17	
			QC 5 - 18	
			QC 5 - 19	
			QC 5 - 22	
			QC 5 - 24	
			QC 5 - 3	
			QC 5 - 43	
			QC 5 - 49	
			QC 5 - 51	
			QC 5 - 58	
			QC 5 - 68	
			QC 5 - 9	
			QC 5 - 50	EL
			QC 5 - 30	
			QC 5 - 40	
			QC 5 - 61	
			QC 5 - 81	
200 Handfinish - 6-1- Touch Up- B4B	1 pcs	0.00 0.10	Handfinish - 6 - 1 - B4B	BEIB 21-04-02
			Handfinish - 6 - 2 - B4B	
			Handfinish - 6 - 3 - B4B	
			Handfinish - 6 - 4 - B4B	
			Handfinish - 6 - 5 - B4B	

			Handfinish - 6 - 6 - B4B	
			Handfinish - 6 - 7 - B4B	
			Handfinish - 6 - 8 - B4B	
			Handfinish - 6 - 9 - B4B	
			Handfinish - 6 - 10 - B4B	
			Handfinish - 6 - 11 - B4B	
			Handfinish - 6 - 12 - B4B	
			Handfinish - 6 - 13 - B4B	
			Handfinish - 6 - 14 - B4B	
			Handfinish - 6 - 15 - B4B	
			Handfinish - 6 - 16 - B4B	
			Handfinish - 6 - 17 - B4B	
			Handfinish - 6 - 18 - B4B	
			Handfinish - 6 - 19 - B4B	
			Handfinish - 6 - 20 - B4B	
			Handfinish - 6 - 21 - B4B	
			Handfinish - 6 - 22 - B4B	
210	Powdercoat - 1 White Gl(A)- B4B	1 pcs	0.00 0.49	Powdercoat - 1 - B4B
				Powdercoat - 2 - B4B
				Powdercoat - 3 - B4B
				Powdercoat - 4 - B4B
220	Handfinish - 3-1- WingWalk- B4B	1 pcs	0.00 0.41	Handfinish - 3 - 1 - B4B
				Handfinish - 3 - 2 - B4B
				Handfinish - 3 - 3 - B4B
				Handfinish - 3 - 4 - B4B
				Handfinish - 3 - 5 - B4B
230	QC 3	1 pcs	0.00 0.00	QC 3 - 10
				QC 3 - 13
				QC 3 - 15
				QC 3 - 17
				QC 3 - 18
				QC 3 - 2
				QC 3 - 28
				QC 3 - 3
				QC 3 - 30
				QC 3 - 34
				QC 3 - 36
				QC 3 - 41
				QC 3 - 51
				QC 3 - 58
				QC 3 - 59
				QC 3 - 68
				QC 3 - 9
				QC 3 - 40
				QC 3 - 19
				QC 3 - 43
				QC 3 - 24
				QC 3 - 61
				QC 3 - 81
				QC 3 - 82
290	Packaging 3-1 - Stock - B4B	1 pcs	0.00 0.00	Packaging 3 - 1 - B4B
				Packaging 3 - 2 - B4B
				Packaging 3 - 3 - B4B
				Packaging 3 - 4 - B4B
				Packaging 3 - 5 - B4B
				Packaging 3 - 6 - B4B
				Packaging 3 - 7 - B4B
				Packaging 3 - 8 - B4B
				Packaging 3 - 9 - B4B

DAS 34 9-89

20-04-3

M 20-4-3

DAS
82
9-89

APR 06 2020

DAS
19
9-89

			Packaging 3 - 10 - B4B	
			Packaging 3 - 11 - B4B	
			Packaging 3 - 12 - B4B	
			Packaging 3 - 13 - B4B	
			Packaging 3 - 14 - B4B	
			Packaging 3 - 15 - B4B	
			Packaging 3 - 16 - B4B	
			Packaging 3 - 17 - B4B	
			Packaging 3 - 18 - B4B	
			Packaging 3 - 19 - B4B	
			Packaging 3 - 20 - B4B	
			Packaging 3 - 21 - B4B	
			Packaging 3 - 22 - B4B	
			Packaging 3 - 23 - B4B	
			Packaging 3 - 24 - B4B	
			Packaging 3 - 25 - B4B	
			Packaging 3 - 26 - B4B	
			Packaging 3 - 27 - B4B	
			Packaging 3 - 28 - B4B	
			Packaging 3 - 29 - B4B	
			Packaging 3 - 30 - B4B	
			Packaging 3 - 31 - B4B	
			Packaging 3 - 32 - B4B	
			Packaging 3 - 33 - B4B	
			Packaging 3 - 34 - B4B	
			Packaging 3 - 35 - B4B	
			Packaging 3 - 36 - B4B	
			Packaging 3 - 37 - B4B	
			QC 21 - SA - 21	
			QC 21 - SA - 70	
			QC 21 - SA - 53	
300 QC 21 - SA	1 pcs	0.00 0.00		

DAS
21
0-00

APR 06 2020

Part Op 110 - Fabricate per Drwg - 1-Cut D2622-120C extrusion to 57.090" long as per Dwg D3168

Descriptions: 120 - QC6- All purchased or subcontracted products

130 - Weld per dwg A/R Aluminum rod Batch: _____ - 1-Bevel end for welding FWD ONLY

140 - QC9- Inspect visual per QSI004- Fusion Welds

150 - QC5- Inspect part completeness to step on W/O

160 - Chemical Conversion Coat per QSI005 4.1

170 - QC7-Inspect Chemical Conversion Coat

180 - Weld per dwg A/R Aluminum rod Batch: _____ Rivet Leg Assembly as per Dwg D3168

190 - QC5- Inspect part completeness to step on W/O

200 - Touch up alodine

210 - White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum - START TIME: _____

220 - Wing Walk as per dwg QSI005 4.4 Batch _____

230 - QC3- Inspect Part Finis

290 - Identify as per dwg & Stock Location: _____

300 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2622-120C	Step Extrusion	.5000 pcs (.5 ea)	110-Large Fab - Steps - 1	5210757
D3067-1	End Plate	1 pcs (1 ea)	110-Large Fab - Steps - 1	5262061
D3067-1	End Plate	1 pcs (1 ea)	180-Large Fab - Steps - 3 - B4B	5262061
D3077-1	Step Leg	2 pcs (2 ea)	180-Large Fab - Steps - 3 - B4B	5081376
D3170-1	Spacer	2 pcs (2 ea)	180-Large Fab - Steps - 3 - B4B	164390
D3219-5	Plate	2 pcs (2 ea)	180-Large Fab - Steps - 3 - B4B	146687
MS20600-AD4W4	Rivet	12 Ea (12 ea)	180-Large Fab - Steps - 3 - B4B	5237978

5043427

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
110-Large Fab - Steps - 1	D2622-120C	1	36	0
	D3067-1	1	92	0
180-Large Fab - Steps - 3 - B4B	D3067-1	1	92	0
	D3077-1	2	4	0
	D3170-1	2	14	0
	D3219-5	2	33	0
	MS20600-AD4W4	12	2,811	0
Part Specifications				
Specifications could not be found.				

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					